

5127

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	23571
<b>Description:</b> Inner Saddle		<b>Part Number:</b>	D2920-1
<b>Dwg:</b> D2920 Rev. A1		<b>Qty:</b>	1
Page 1 of 1			

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Dwg not required	AF	05.06.23	1
2	MV	Cut blanks: 2.500" x 8.250" x 7.950" grain along 7.950" Material: 6061-T6/T651 (QQ-A-250/11) (D6102-011) Identify as D2920-1 Batch: B23642	EC	05.06.29	1
3	MV	Program batch number	EC	05.06.29	1
4	MV	Machine Step No 1 as per Folio FA534 and visually inspect as per Dwg D2920 & attached Dimension Sheet	EC	05.06.29	1
5	MV	Machine Step No 2 as per Folio FA534 and visually inspect as per Dwg D2920 & attached Dimension Sheet	EC	05.06.29	1
6	MV	Machine Step No 3 as per Folio FA534 and visually inspect as per Dwg D2920 & attached Dimension Sheet	EC	05.06.29	1
7	MV	Machine Keyway and inspect per Dwg D2920 & attached dimension sheet	EC	05.06.29	1
8	MV	Deburr	EC	05.06.29	1
9	QC2	Inspect parts as they come off the CNC machine	EC	05.06.29	1
10	QC8	Second inspection	CP	05.06.30	1
11	FP	Acid etch and Alodine as per QSI 005 4.1	ML	05.07.04	1
12	FP	Powder Coat Gloss White (4.3.5.1) as per Dart QSI 005 4.3	ML	05.07.04	1
13	QC3	Inspect Powder Coat	CL	05.07.05	1
14	ST	Identify and Stock	CL	05.07.05	1
15	AC	Cost / part 443.44	SAC	05.07.06	1
16	DC	Close W/O 443.44 Inspect Level 21	AF	05.07.15	1

Rev	Date	Change	Revised By	Approved
A	05.06.23	New Issue	KJ/JLM	

RELEASED  
05.06.23

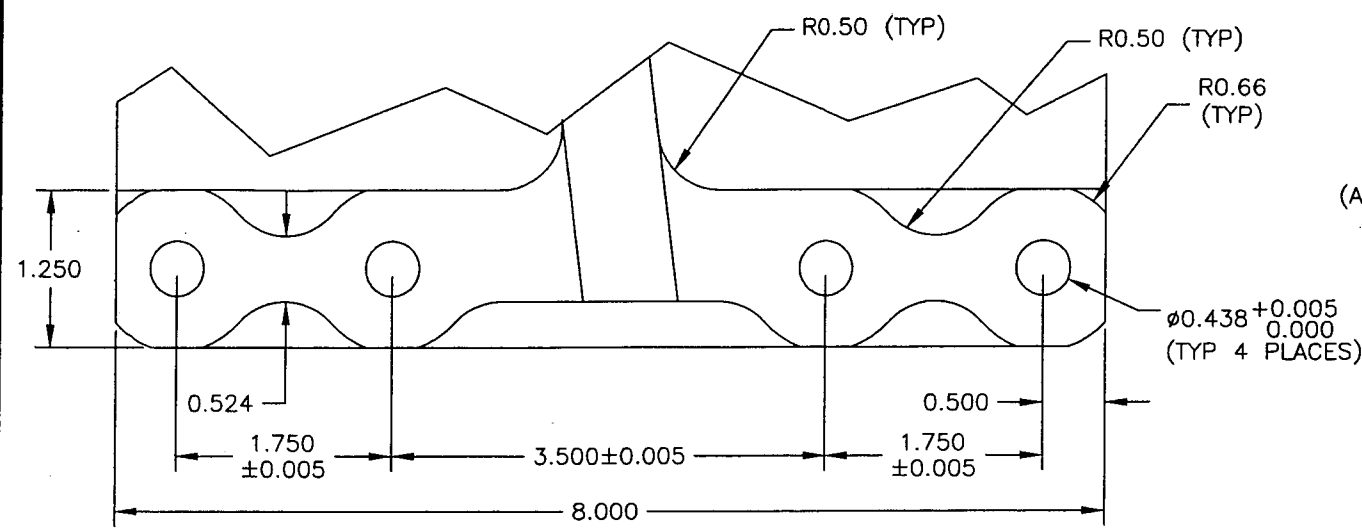
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
05.06.22	2	Permanant Change	<i>[Signature]</i>	05.06.22	N/A		

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

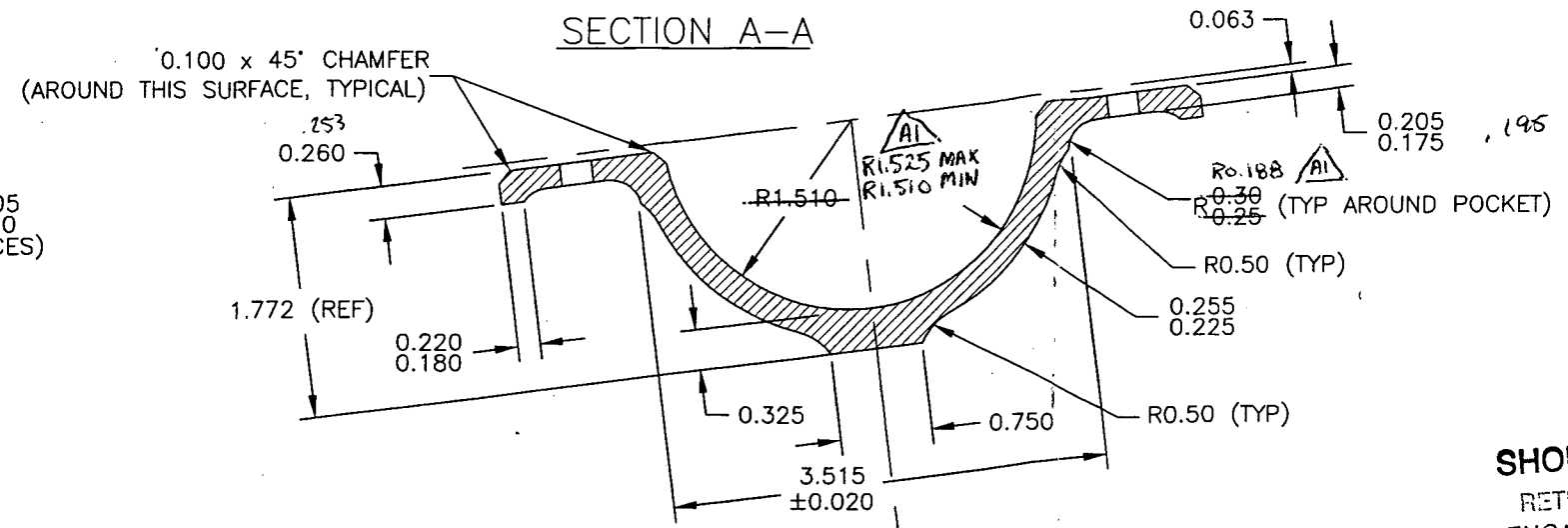
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



VIEW B-B

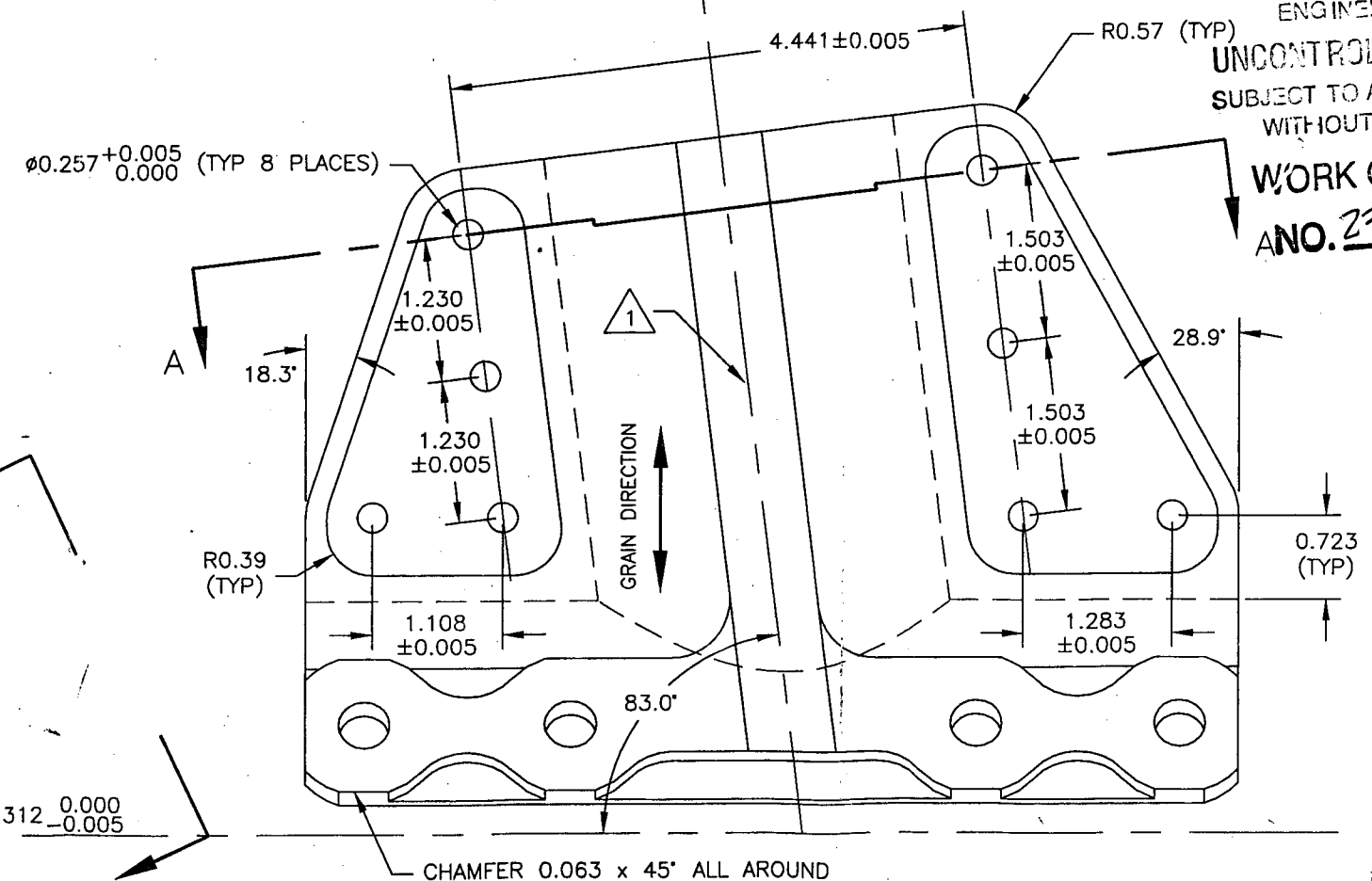
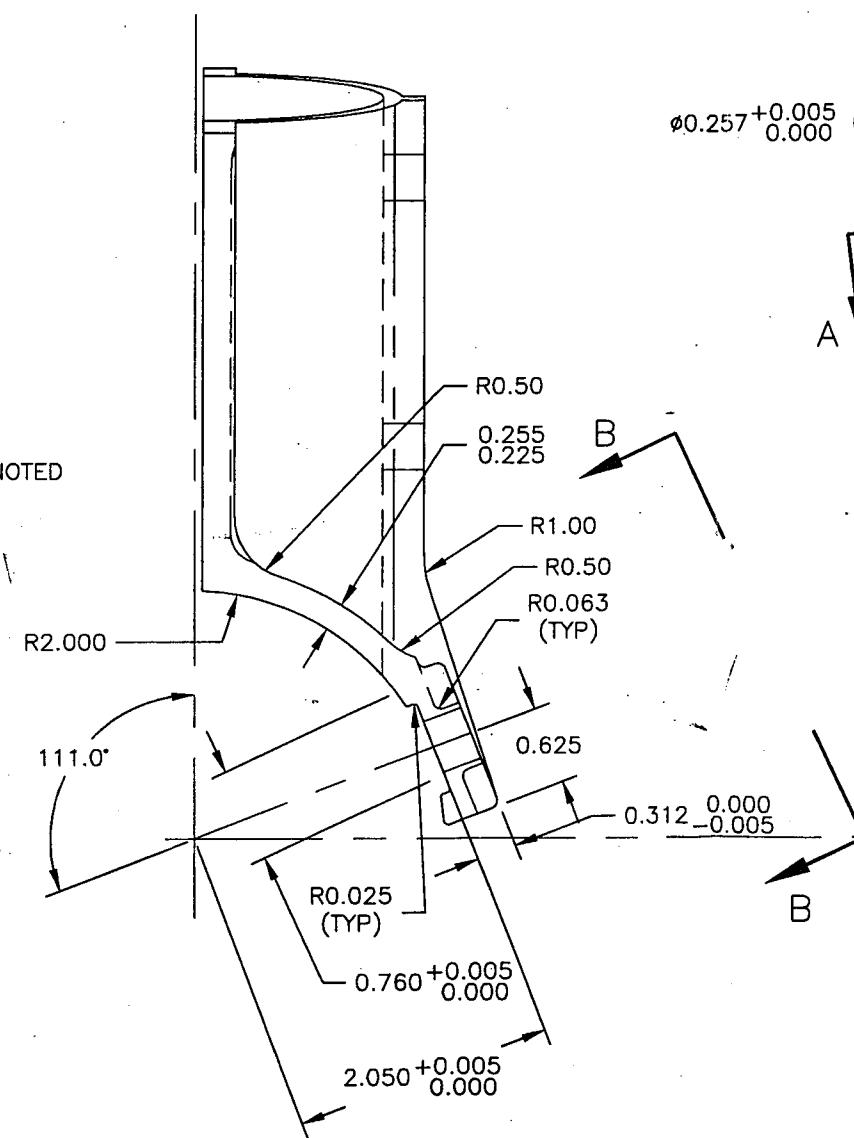


D2920-1 LH SADDLE (SHOWN)  
D2920-2 RH SADDLE (OPPOSITE)

MATERIAL: 6061-T6 OR 6061-T651 (QQ-A-250/11)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010

RELEASED



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
ANO. 23571

AI	04.08.13	CHANGE RAD & TOLERANCE
A.	04.06.22	NEW ISSUE
DESIGN	DRAWN BY	<b>DART</b> DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2920
DATE	04.06.22	TITLE INNER SADDLE
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		REV. A SHEET 1 OF 1 SCALE 2:3

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Jun 16, 2005  
08:04 am

Work Order No : 0023571  
Project Name : D2920-1  
Project For : WK527  
Work Order Type : Main  
Main WO Number :  
House Part Number : D2920-1  
Description : Saddle LH  
Manufactured : No  
Amount Req'd : 0  
Amount Done : 0  
Start Date : 06-14-05  
Est Finish Date : 07-04-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
  
Order Entry No :  
OE Value : 0.00  
  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00

DART AEROSPACE LTD		Work Order:	23571
Description:		Part Number:	D2920-1
Inspection Dwg:	Rev:	Page 1 of 2	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.250	$\pm 0.01$	1.249	✓			
$\phi .438$	$+0.005$ $-0.008$	$\phi .439$	✓			
0.500	$\pm 0.01$	0.508	✓			
1.750	$\pm 0.005$	1.751	✓			
3.000	"	3.498	✓			
1.750	"	1.748	✓			
8.000	$\pm 0.01$	8.008	✓			
0.524	"	0.523	✓			
<hr/>						
0.100 x 45°	$\pm 0.01 / \pm 0.5^\circ$	0.097 x 45	✓			
1.525 / 1.510	N/A	1.515	✓			
0.205 / 0.175	"	0.195	✓			
R.188	$\pm 0.01$	R.188	✓			
0.255 / 0.225	N/A	0.244	✓			
R.0.50	$\pm 0.01$	R.50	✓			
0.750	$\pm 0.01$	0.748	✓			
3.515	$\pm 0.02$	3.527	✓			
0.325	$\pm 0.01$	0.322	✓			
0.220 / 0.180	N/A	0.220	✓			
1.772	$\pm 0.01$	1.770	✓			
0.260	$\pm 0.01$	0.255	✓			
<hr/>						

Measured by:	<i>RE</i>	Audited by:	<i>CP</i>	Prototype Approval:	<i>CP</i> 05.06.30
Date:	05.06.29	Date:	05.06.30	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order:	23571
Description:		Part Number:	02920-1
Inspection Dwg:	Rev:	Page 1 of 2	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.441	$\pm 0.005$	4.443	✓			
1.503	"	1.503	✓			
1.503	"	1.502	✓			
6.723	$\pm 0.01$	6.728	✓			
1.283	$\pm 0.005$	1.284	✓			
83°	$\pm 0.5°$	83°	✓			
1.108	$\pm 0.005$	1.107	✓			
1.230	"	1.228	✓			
1.230	"	1.230	✓			
Ø.257	$\pm 0.005$ $-0.000$	Ø.259	✓			
2.50	$\pm 0.01$	2.50	✓			
0.255/0.225	N/A	0.235	✓			
0.760	$\pm 0.005$ $-0.000$	0.764	✓			
0.312	$\pm 0.005$ $-0.005$	0.312	✓			
2.050	$\pm 0.005$ $-0.000$					Can't measure
0.625	$\pm 0.01$	0.627	✓			

Measured by: <i>RE</i>	Audited by: <i>CP</i>	Prototype Approval: <i>CP</i> 05.06.30
Date: 05.06.29	Date: 05.06.30	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	